

**What is claimed is:**

1. A circular tubular heat pipe having a sealed structure closing a distal opening thereof, wherein an improvement of the sealed structure comprises:

5           a concave wall portion formed on a region of the heat pipe adjacent to the distal opening;

          a pressed recess portion formed on the concave wall portion adjacent to the distal opening, the heat pipe being formed to have a overlapping wall at the pressed recess portion;

10           a volume reduced portion formed on the pressed recess portion adjacent to the distal opening; and

          a sealed welding portion formed on the volume reduced portion at the distal opening, thereby reducing an area of the sealed welding portion.

15           2. The circular tubular heat pipe as claimed in claim 1, wherein the pressed recess portion is a semi-circle in cross section.

          3. The circular tubular heat pipe as claimed in claim 1, wherein the pressed recess portion is an arc shape in cross section.

20           4. The circular tubular heat pipe as claimed in claim 1, wherein the pressed recess portion is a V-shaped in cross section.

          5. The circular tubular heat pipe as claimed in claim 1, wherein the volume reduced portion is an ellipse in cross section.

25           6. The circular tubular heat pipe as claimed in claim 1, wherein the volume reduced portion is a pair of symmetric flat walls in cross section.

7. The circular tubular heat pipe as claimed in claim 1, wherein the volume reduced portion is a curled shape in cross section.

8. The circular tubular heat pipe as claimed in claim 1, wherein the volume reduced portion is further welded.

5            9. The circular tubular heat pipe as claimed in claim 1, wherein the pressed recess portion is spot welded.

10. The circular tubular heat pipe as claimed in claim 1, wherein the pressed recess portion is ultrasonically welded.